

Work Order ID 150859

Thursday, September 08, 2016 11:10:02 AM

150859

Page 1

Item ID: D4777-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rod End Bearing
Start Date: 9/19/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: **SEP 08 2016** Tooling: Date: Run Start ***NR1***
QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4777	A

100	PURCHASING	0.00							DAS 13 9-89
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 33587								

Purchase Part Number: 59915K274 Supplier: Mc Master Carr or CTG
Certificate of conformity is required

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.02							
Packaging	Ensure certificate of conformity is attached								

120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 38 9-89
SEP 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>St 125</i>	0.00							
130									
Packaging	Memo	0.01							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
21
9-89

SEP 14 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

Picklist Print

Thursday, September 08, 2016 11:10:07 AM

Page 1/1

Work Order ID: 150859

150859

Parent Item: D4777-1

D4777-1

Parent Item Name: Rod End Bearing

Start Date: 9/19/2016

Required Date: 9/23/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
59915K274		Purchased			No	110	Each	0.0000	1	6			
59915K274									**				
Rod End Bearing													

Ex 8016-9-12

DQA: _____ Date: _____



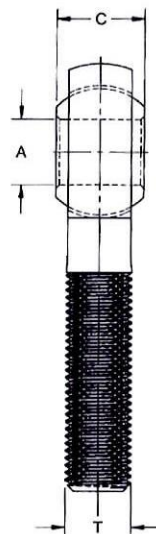
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

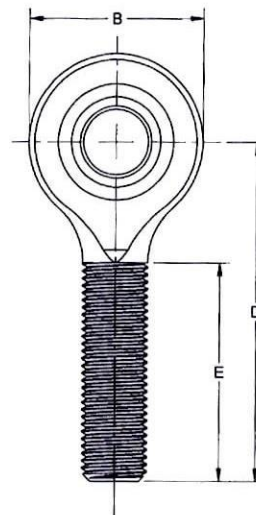
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SPECIFICATION CONTROL DRAWING



ROD END BEARING



SHOP COPY
RETURN TO
ENGINEERING
(UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 150859 MJS
16 09-08

DART P/N	HOUSING MATERIAL	A	B	C	D	E	T (THREAD SIZE)	SUGGESTED SUPPLIER	SUGGESTED SUPPLIER P/N
D4777-1	STAINLESS STEEL	Ø 0.38	1.00	0.500	1.94	1.25	3/8-24 (RIGHT HAND)	MC MASTER CARR	59915K274

RELEASED
2013-08-14
W

A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	13.08.08		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4777	REV. A SHEET 1 OF 1
TITLE ROD END BEARING	SCALE NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33587**

Purchase Order Date 9/8/2016

PO Print Date 9/8/2016

Page Number 2 of 3

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Total: \$36.78

4 63215K52

Bearing Spherical

9/13/2016

Yes

9/13/2016

12.00

Each

\$15.62

\$187.44

AS PER DWG D3965 REV. B
B150860

Line Total: \$187.44

5 59915K274

Rod End Bearing

9/13/2016

Yes

9/13/2016

6.00

Each

\$19.05

\$114.30

AS PER DWG D4777 REV. A
B150859

Line Total: \$114.30

6 86715K27

Adhesive Rubber Seal 60A
durometer

9/13/2016

Yes

9/13/2016

6.00

Each

\$16.73

\$100.38

AS PER DWG 601.3083
B150862

Note:

9/8/2016



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Eric.D

Purchase Order
PO33587

Order Placed By
Chantal Lavoie

McMaster-Carr Number
8285477-02

Page 1 of 1

09/08/2016

Line	Product	Ordered	Shipped
1	6641A41 Loctite Gasket Maker, #598, 2.36 oz Tube	8 Each	8
3	97395A451 Corrosion Resistant Dowel Pin, Type 316 Stainless Steel, 1/8" Diameter, 3/4" Length, Packs of 10	3 Packs	3
4	63215K52 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 1/4" ID, 21/32" OD, 11/32" Ball Thick	12 Each	12
5	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	6 Each	6
6	2340A11 Mitutoyo Harsh Environment Electronic Caliper, Number 500-752-20, 0-6" (0-150MM) Range	2 Each	2

Shipped separately from our Atlanta warehouse on 09/08

2	9928K53 Impact-Resistant UHMW Polyethylene U-Channel, 1" Base X 3/4" Legs, 1/4" Thick, 8' Long	32 Feet	32
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Notes about your shipment

The U.S. Department of Transportation regulates the shipping of line 6. By purchasing from McMaster-Carr Supply Company, you agree not to transport or permit others to transport purchased items except in accordance with U.S. law and any other applicable laws.